

Date: Thursday, 04/09/2008 1:23:02 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 206 L WEB
<b>Job Number</b>	: 41821		
<b>Estimate Number</b>	: 10722		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D26547
<b>This Issue</b>	: 04/09/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2654 REV E1
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 41437	<b>Drawing Revision</b>	: E1
	<b>Type</b> : SKIDTUBES	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 28/09/2008
<b>Checked &amp; Approved By</b>	: <u>2008-9-09</u>	<b>Qty:</b>	4 Um: Each
<b>Comment</b>	: Est Rev:D 99.02.04 Fixed typo, Changed procedureDM Est Rev:e 06.04.05 Added level21 EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D26007140	EXT. "I BEAM" THICK
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-7- 140	Web	21966

2508-09-09

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-7 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

2508-09-09

(24)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

8-9-9

(4)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

2508-09-09

K4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

Date: Thursday, 04/09/2008 1:23:02 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 41821

Part Number: D26547

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



8-9-9-4

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

L-6 8-9-9 AWM



7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/09

Job Completion



mf 68-09-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector






Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

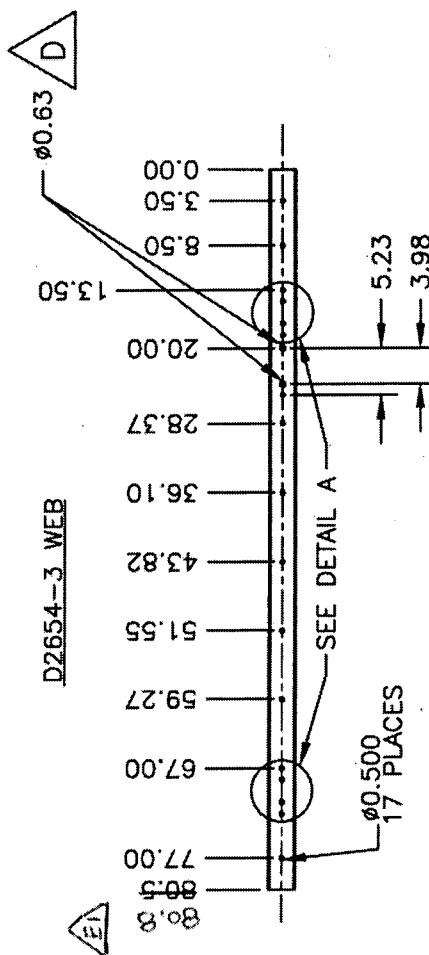
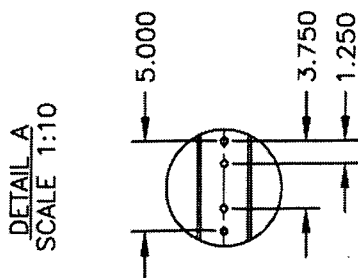
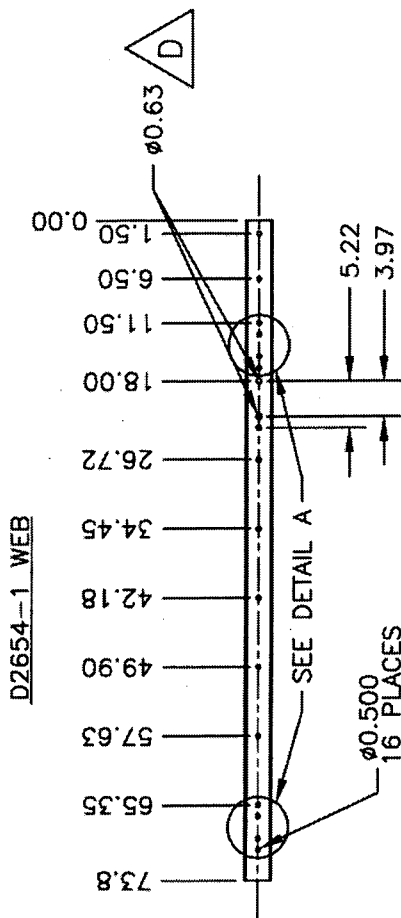
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



DESIGN 		DRAWN BY 		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26				TITLE WEB	SCALE 1:20
A	97.03.25		NEW ISSUE		
B	97.06.26		ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29		CHANGED HOLE PATTERN		
D	98.01.15		GHW HOLES CHANGED TO Ø0.63		
E	04.05.26		CHANGE LENGTHS, REFORMAT		
E1	 04.08.04		PER TOOLING; 80.8 WAS 80.5		

RELEASED  
04.06.22



MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

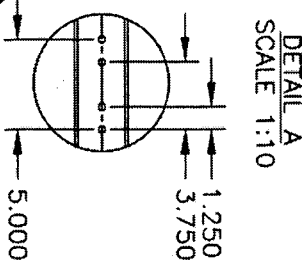
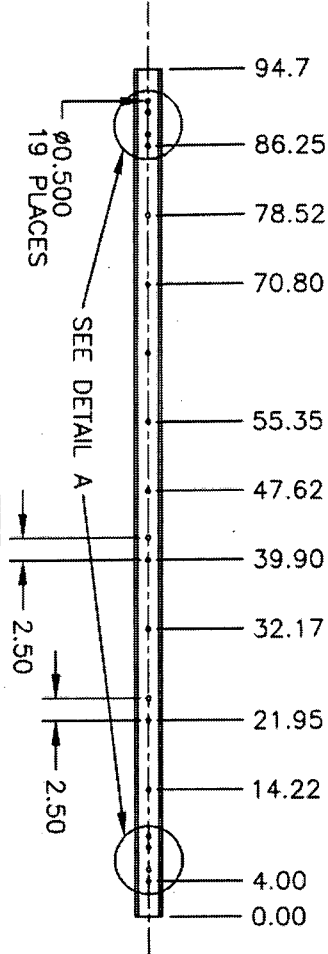
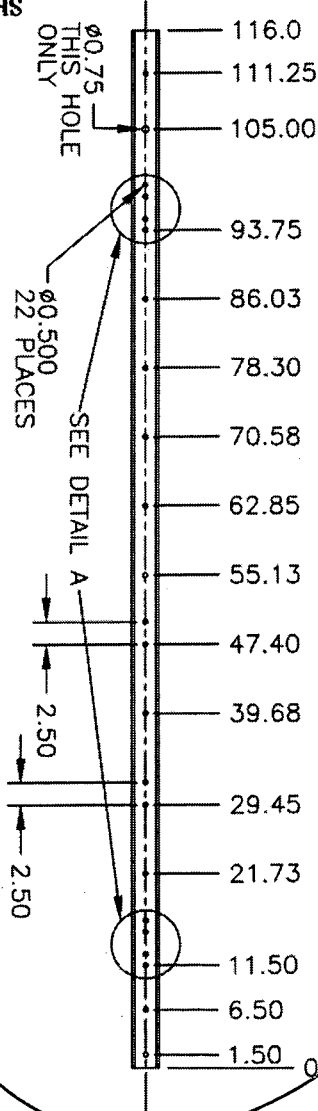
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MAKE FROM D2600-7-125 EXTRUSION  
 FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1  
 TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED



RELEASED  
 04.05.26

DESIGN	CHECKED	DATE	04.05.26
DRAWN BY	APPROVED	TITLE	WEB
DART AEROSPACE USA, INC.	D2654	SCALE	1:20
PORT HADLOCK, WA	SHEET 2 OF 2	REV. E	